ASAP

Work Order ID 73721

Wednesday, September 14, 2011 12:02:52 P

Item ID: D3290-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Window Assembly

Start Date: 9/14/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** R **Date:** 11-09-11 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3290	DEO Rev C1								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				BJ 1-9-27			
FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev: C1 Prog Rev: C1 2-Deburr if necessary							(10)	
6061 . 063									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				BJ 1-9-27			
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				(10)			
Quality Control									

S 11/09/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

10 counted d ll 11/09/27

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30 OVEN TEMPERATURE: 320°F FINISH TIME: 4:00								
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

M118439

10X Ø m-f 11/09/27

10 BK 11-9-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Small Fab	0.00							
Small Fab						x8			Sh 11/10/03. PTO
Small Fab	**Memo**	0.00							
	Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap								
170	QC5- Inspect part completeness to step on W/O	0.00							
QC		Sulcolay				(x8)			
Quality Control	**Memo**	0.00							
180	Identify as per dwg & Stock Location: ST	0.00	St 219						
Packaging	x2 Lunch Room					(8)	SP11-10-5		Wh 11/10/03
Packaging	**Memo**	0.00							

Dart Aerospace Ltd

W/O: 73721	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
44D-03	160	stock 2 x D3290-1 frames with same B/N	DL	14/10/06	2	CE 44D-03	S 14/10/06

Part No: D ~~3756~~ 3290-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73721

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Required Date: 9/16/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					11/10/6		
QC Quality Control	Memo	0.00							

MF
11-10-6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, September 14, 2011 12:02:50 PM

Work Order ID: 73721

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 9/14/2011 **Required Date:** 9/16/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments:
IPP B□05.05.25□Added Step 11□KJ/JLM□
IPP C□06.05.09□Ecn 798 EC□
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	198.9456	3.75	23.68421	38.		
6061-T6 .063 Sheet										(B119-27)			
				Location		**Loc Qty**		**Loc Code**					
				MAT021		198.9455684							
					116308	26.9755684							
					117285	98.97							
					118580	73				118 SQ			
D2126		Manufactured	No			160	f	275.5058	6.5	39			
Seal													
				Location		**Loc Qty**		**Loc Code**					
				ST405		275.50579							
					57106	4							
					68336	271.50579				55 ft.			
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***													
D3290-3		Manufactured	No			160	Each	0.0000	1	6			
Window										x 8			

(10)

Dh 11/10/05

B-73454.

Dh 11/10/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	13721
Description: Window Frame	Part Number:	D3290-1
Inspection Dwg: D3290 **Rev:** C		Page 1 of 1

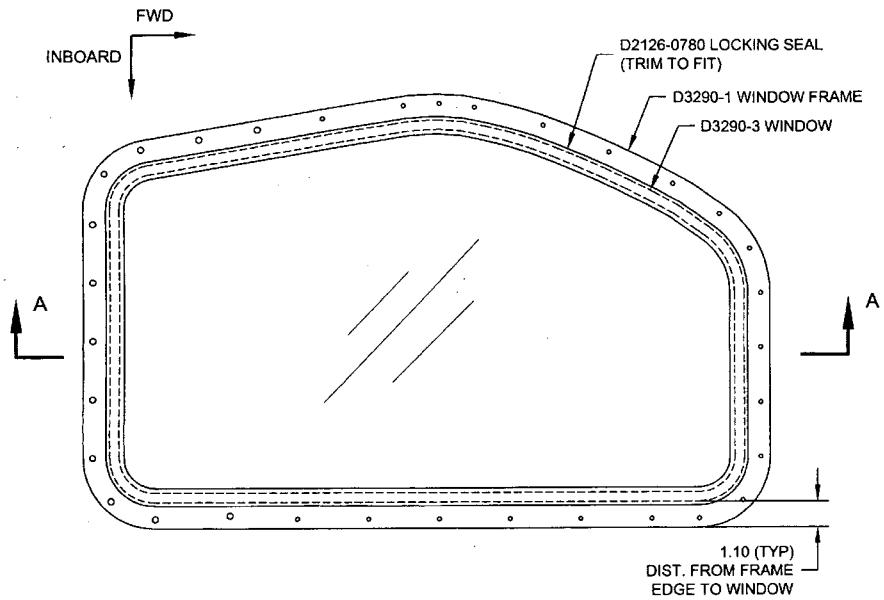
FIRST ARTICLE INSPECTION CHECKLIST

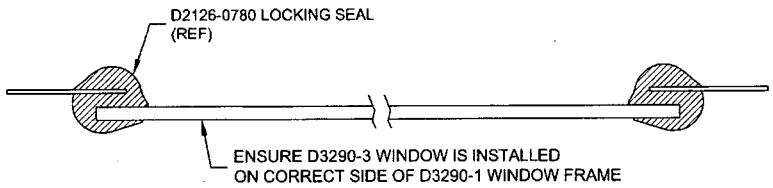
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00			T IB01	
14.00	+/-0.030	14.00			T	
Ø0.171	+0.005/-0.001	.172			V IB02	
1.50	+/-0.030	1.512			V	
1.11	+/-0.030	1.111			V	
10.10	+/-0.030	10.10			T	
18.50	+/-0.030	18.50			T	
0.063	+/-0.010	.064			V	
R3.00	+/-0.030	3.00			R.G	
R4.50	+/-0.030	4.50			R.G	
Ø0.257	+0.006/-0.001	.259			V	
13.61	+/-0.030	13.61			T	

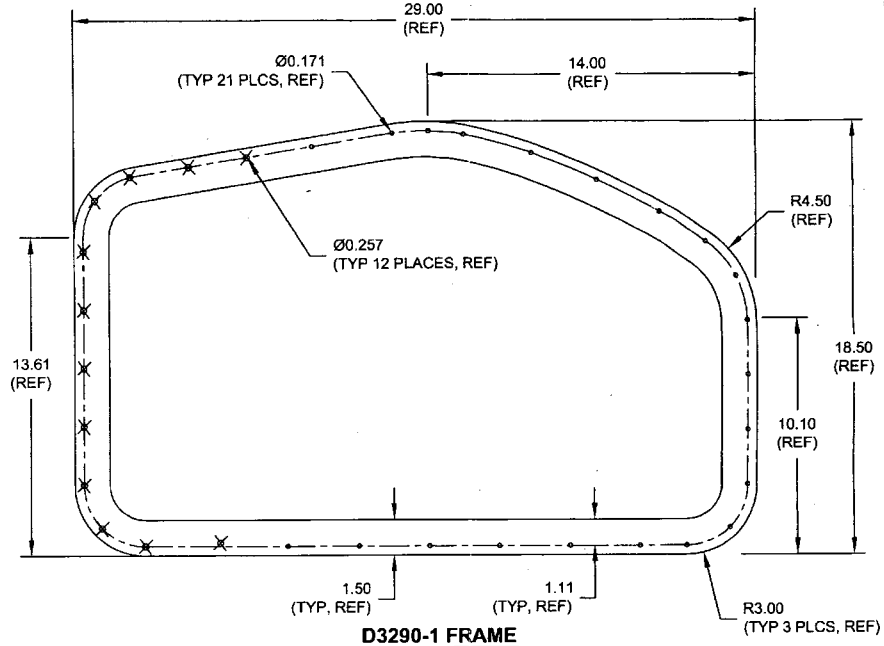
Measured by:	IB	Audited by:	[illegible]	Prototype Approval:	N/A
Date:	11-9-07	Date:	11/09/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	





SECTION A-A
NTS



D3290-1 FRAME

D3290-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED 07.09.22

DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73721

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

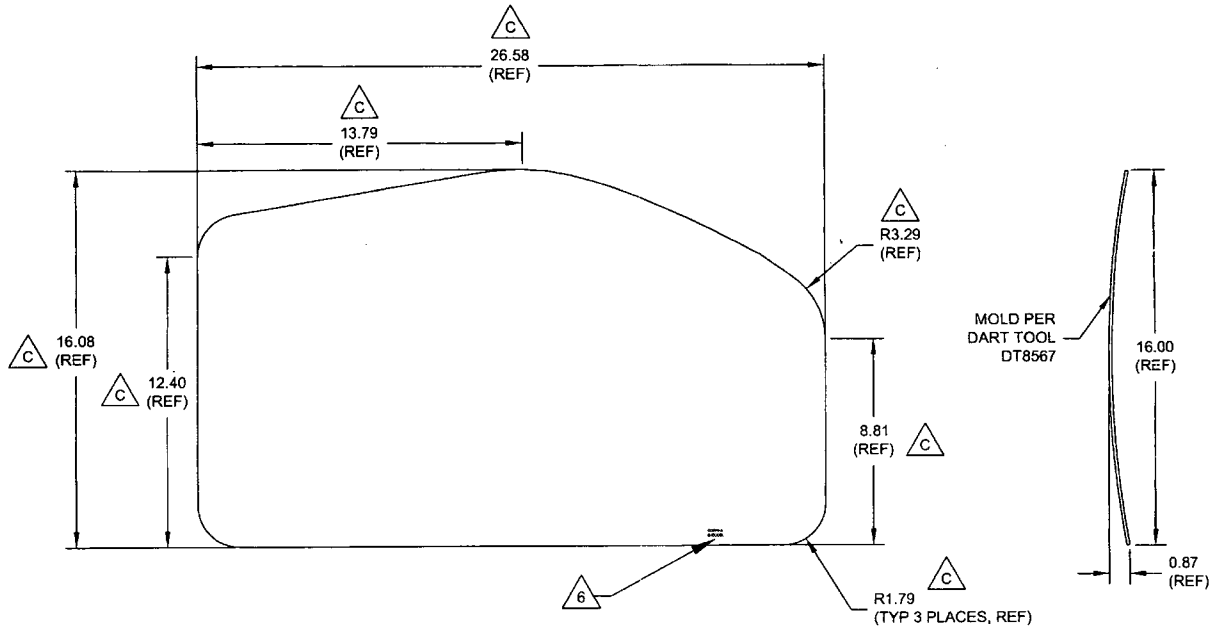
GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

11-09-14

UNDER REVIEW
09.07.19
09/10/19

REV.	DESCRIPTION	BY	DATE
C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3290 — REV. C — SHEET 1 OF 2
CHECKED		TITLE: REPLACEMENT WINDOW ASSEMBLY — SCALE 1:5
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	07.07.24	



D3290-3 WINDOW

D3290-3 NOTES:

B

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) REMOVE SHARP EDGES
6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
7) WEIGHT: 1.87 +/- 0.42 LBS
8) MOLD PER DART TOOL DT8567

13721

UNDER REVIEW

DEO ATTACHED

RELEASED 07.09.22

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	

DRAWING NO.	TITLE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3290	REPLACEMENT WINDOW ASSEMBLY			D3290-C-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
OR
5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
2009 -10- 09

73721